

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Page 2

Setup Start *NS1*

Stop *NS2*

Start Date: 5/5/2016 **Start Qty:** 10.00

Required Date: 5/19/2016 **Req'd Qty:** 10.00

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.10

Quality Control

DAS

14

9-39

14/04/35

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.20

Quality Control

10

5116-5-3

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.40

Hand Finishing

10.

20

16/05/07

DQA: _____ Date: _____



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

Work Order ID 144604

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144604

Page 3

Item ID: D3264-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 5/5/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 5/19/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum <i>M134631</i> Memo	0.00 0.20	<i>START: 11:05</i> <i>W.T: 320°</i> <i>FINISH: 11:35</i>			<i>10</i>	<i>0</i>	<i>1605-17</i>	<i>238</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.10				<i>(10)</i>			DAS 38 9.89 MAY 17 2016
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>5493</i> Memo	0.00 0.10				<i>10</i>		<i>MAY 17 2016</i>	DAS 8 9.89

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OTHER : ☐									

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Page 4

Reference:

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

MLJ MAY 18 2016

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WORK ORDER NON-CONFORMANCE / UPDATE

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 144604

144604

Parent Item: D3264-1

D3264-1

Parent Item Name: Bracket

Start Date: 5/5/2016

Required Date: 5/19/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A04.09.02New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X04.50 0		Purchased		No			f	9.1000		5			

M6061T6B1 250X04 500

6061-T6 Bar 1.25 X 4.50

Location

Loc Qty

Loc Code

MAT

2.75

✈ m131653

2.75

MAT004

6.35

m133038

6.35

2.75

3.

DAS

14

9-33

16/04/26

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order:	144604
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	.687	—		Veri M-06	
0.063	+/-0.010	.062	—		"	
0.125	+/-0.010	.128	—		"	
0.875	+0.010/-0.020	.879	—		"	
0.062	+/-0.010	.062	—		"	
R0.03	+/-0.030	R.030	—		R-6	
R0.13	+/-0.030	R.125	—		"	
1.00	+/-0.030	1.003	—		Veri M-06	
0.125	+/-0.010	.125	—		"	
0.600	+/-0.010	.600	—		"	
4.000	+/-0.005	4.000	—		"	
0.750	+/-0.010	.750	—		"	
Ø0.194	+0.005/-0.000	Ø.196	—		"	
5.50	+/-0.030	5.499	—		"	
0.125	+/-0.010	.125	—		"	
0.063	+/-0.010	.065	—		"	
R0.25	+/-0.030	R.250	—		"	
4.27	+/-0.030	4.267	—		"	
R0.30	+/-0.030	R.300	—		"	

DAS

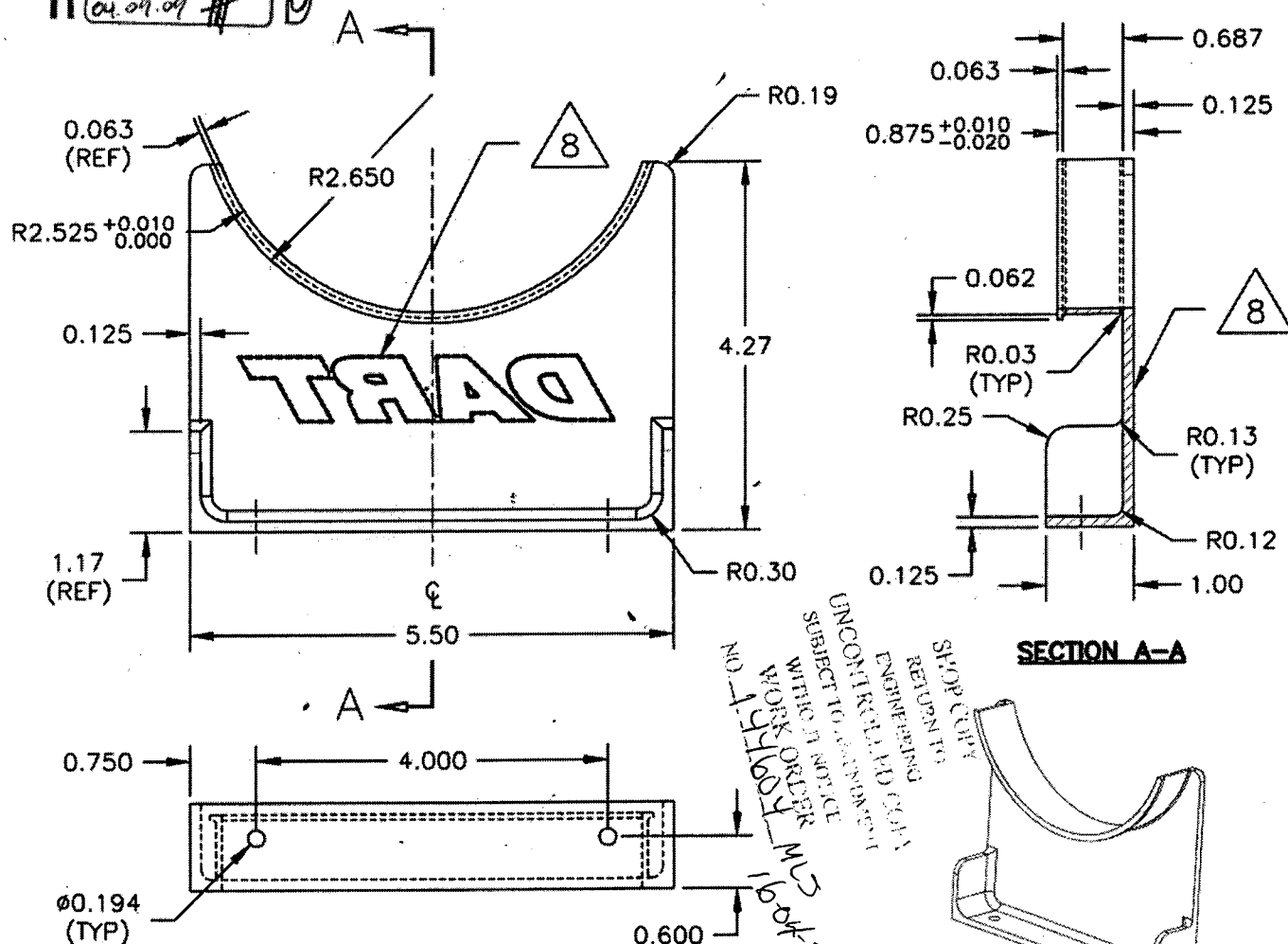
Measured by:	14 2-60	Audited by:	SL	Prototype Approval:	N/A
Date:	16/04/30	Date:	16-5-3	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	



DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D3264 REV. A SHEET 1 OF 1	
DATE 04.04.20		TITLE BRACKET		SCALE 1:2	
A		04.04.20		NEW ISSUE	

RELEASED
04.09.09 #



D3264-1 BRACKET

03264-1;

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010
6) PART IS SYMMETRIC ABOUT CENTERLINE
7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH
(MIN) TOOL RADIUS OF 0.25

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